

shg today 22/05

Work Order ID 84706

May-22-12 9:24:25 AM

84706

PRELIMINARY ISSUE

Page 1

Item ID: D4632-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Striker Plate
 Start Date: 22/05/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 25/05/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ML Date: 12/05/22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4632	PA1

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304, 050	Dwg Rev: <u>PA1</u>								
	Prog Rev: <u>PA1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				(2)			JB 17/6/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							- 1/2 parts to PA) Day on line, 8/2/12/22 (72)
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							12/5/22

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Work Order ID 84706***84706***

Page 3

May-22-12 9:24:25 AM

Item ID: D4632-2

Accept

N900040100Setup Start ***NS1***

Revision ID: PRELIM

Stop ***NS2***

Item Name: Striker Plate

Start Date: 22/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*W 20522***POSITIVE RECALL**EFFECTIVE 12.05.22 AUTH W

RELEASED _____ DATE _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

May-22-12 9:24:28 AM

Work Order ID: 84706

84706

Parent Item: D4632-2

D4632-2

Parent Item Name: Striker Plate

Start Date: 22/05/2012

Required Date: 25/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

249.2860

0.05

0.105263

M304S18GA

**

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

248.96421

120604

24.96421

121626

128

121660

96

MAT20

0.32179

121192

0.32179

119188

119188

Jm
12-5-22

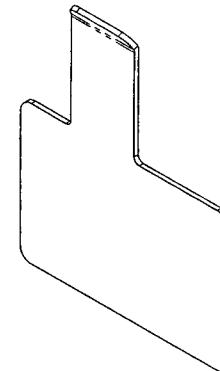
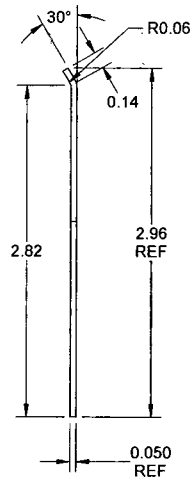
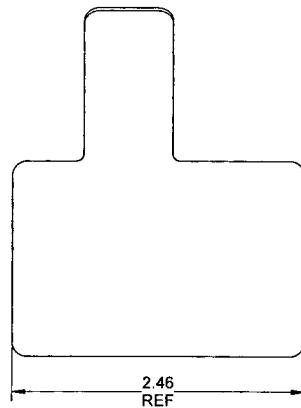
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NOTE: Date & initial all entries



D4632-1 STRIKER PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 24706 MJ
12/05/22

PRELIMINARY ISSUE

[Signature] 12.05.14

NOTES:

- 1) MATERIAL: MAKE FROM D4632-1F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

PA1	NEW ISSUE	RF	12.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.		D4632	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE	NTS
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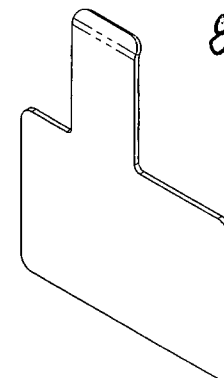
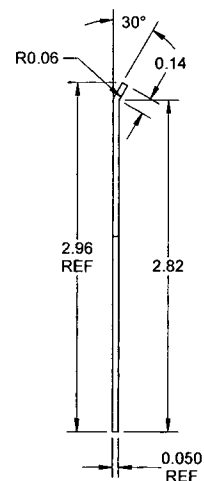
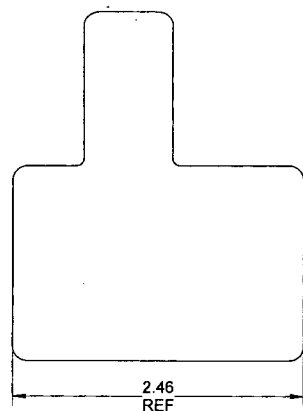
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NOTE: Date & initial all entries



D4632-2 STRIKER PLATE

PRELIMINARY ISSUE

12.05.14

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- 1) MATERIAL: MAKE FROM D4632-1F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

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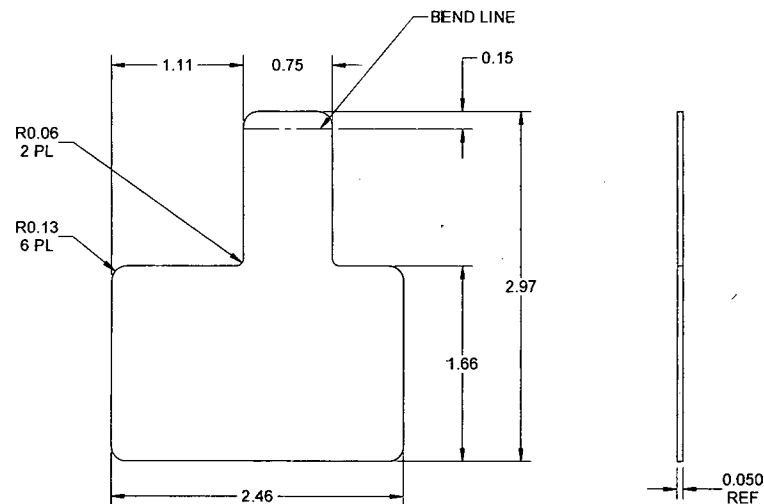
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NOTE: Date & initial all entries

24700



D4632-1F FLAT PATTERN STRIKER PLATE

NOTES:

1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.07 lbs

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12.05.14

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
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